



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18407-3
Job Sheet 181527



Part No: RBT18407-3

Job Qty: 8 ea

Part Name: Adapter, Jacking



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 7/31/18

Job Tracking No:

Due Date: 7/31/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT18407 Rev A IPP Rev A 18.03.08 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
90	Start up Operation	6 Ea	7/31/18	7/31/18	0.00	0.00	Start Up Machining		
100	Mori Seiki	6 pcs	7/31/18	7/31/18	0.00	3.00	MORI SL-154		
105	QC	6 pcs	7/31/18	7/31/18	0.00	0.00	QC2 Machining-2		
108	Mori Seiki	6 pcs	7/31/18	7/31/18	0.50	2.00	MORI NV5000-1		
110	QC	6 pcs	7/31/18	7/31/18	0.00	0.00	QC2		
120	QC	6 pcs	7/31/18	7/31/18	0.00	0.00	QC8		
123	QC	6 pcs	7/31/18	7/31/18	0.00	0.00	QC5		
130	Packaging	6 pcs	7/31/18	7/31/18	0.00	0.00	Packaging3		
140	QC21-SA	6 Ea	7/31/18	7/31/18	0.00	0.00	QC21		

Part Op 100 - 1-Machine as per DWG. FC284 FOLIO REV: AA DWG REV: 4 2-Deburr
Descriptions: 108 - 1-Machine as per DWG. FC284 FOLIO REV: AA DWG REV: 4 2-Deburr
110 - Engrave ADAPTER JACKING P/N:RBT18407-1 using Marktronic engraver as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R1.500	304 Round Bar 1.500	1.5600 ft (.26 ea)	90-Start up Operation	M 935559

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R1.500	2	2	0

Part Specifications



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

d.

Plex 7/31/18 8:52 AM dart.logan.david

Container No: S098030



Part: RBT18407-3

Job No: 181527

Serial No/Batch: S098030

Revision: 4

Inspector:

Exp Date:

Instructions:

DART AEROSPACE LTD		Work Order:	180980
Description: adapter, Jacking		Part Number:	
Inspection Dwg: RBT 18407-3	Rev: 4	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.080	±.005	.080	✓			
Ø.110 x .118	±.005 / .5°	.110 x .118				
.18	±.01	.18				
.125	±.005	.125				
.125	±.005	.125				
9/16-18 UNJF-3A						
Major .5582	±.0044	.5585	✓		Mic LPO1	
Wire Ø.032					↓	
Down .5718	±.0009	.5710			↓	
Ø1.00	±.01	1.000			vern LPO9	
.750	±.005	.748			↓	
.090	±.005	.090			↓	
1.0	±.1	1.000			↓	
.25	±.01	.250			↓	
1.188	±.005	1.190	✓		HG.	
.125	±.005	.125				
R.03	±.01	.032			Rad.	
R.03	±.01	.032			↓	
R.06	±.01	.061			↓	
R.03	±.01	.032			↓	
.06 x 45°	±.01 x .5°	.062 x 45			vern LPO9	
.999	±.000 / ±.003	.998			Mic LPO1	
.500	±.005	.499	✓		↓	

Measured by: <i>[Signature]</i>	Checked by: <i>[Signature]</i>	QC Inspector:
Date: 18-07-31	Date: 18/07/31	Date:

Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE**DART**
AEROSPACE

QA Closed: _____ Date: _____

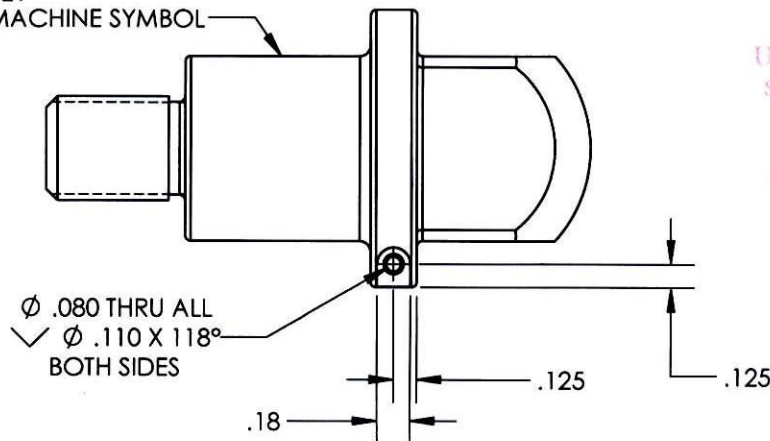
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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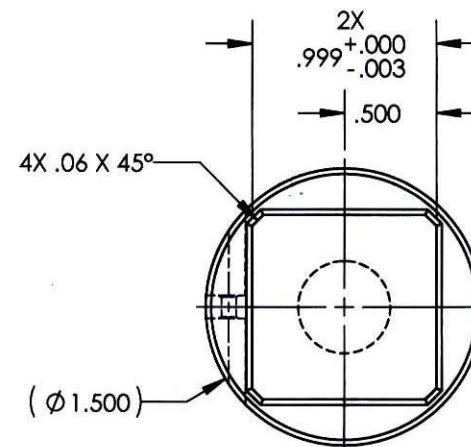
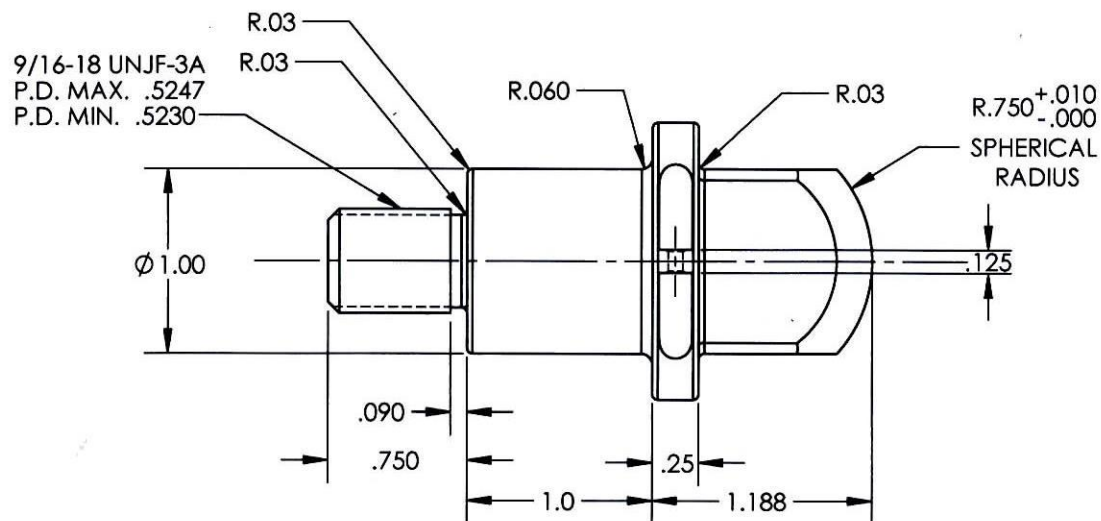
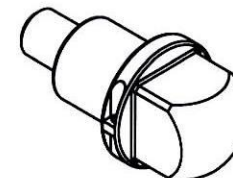
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
3	CH'D -3 DIMENSION FROM .850 TO .750, ADDED MAX. & MIN. PITCH DIAMETERS TO 9/16-18 UNFJ-3A.	11/8/2012	RJC	DW

ENGRAVE:
ADAPTER JACKING
P/N: RBT18407-1
CAGE: 01AE1
REDBARN MACHINE SYMBOL



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 18080

20180718



2.970

(3)

ADAPTER, JACKING

RED BARN MACHINE	
TITLE ADAPTER SET, AIRCRAFT JACKING	
DWG NO. RBT18407-3	REV 4
MAT'L 304 S.S.	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Wed</i>
.XXX $\pm .005$	FRACTIONS $\pm 1/32$
.XX $\pm .01$	ANGLES $\pm 5^\circ$
.X $\pm .1$	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	REMARKS
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	FIREBIRD
SCALE 1:1	DATE 9/19/2012
SHEET 3 OF 7	